



Lean Is...

- “LEAN IS – from an operations perspective... a system that cuts costs & inventories rapidly to free cash, which is critical in a slow economy. It also supports growth by improving productivity and quality, reducing lead times and freeing huge amounts of resources.
- Lean aims at reducing (if not eliminating) none value added activities in business processes.
- It’s not a project.

Work Order ID 57824

April 16, 2010 10:51:44 AM



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Item ID: D3909-1

Accept



Setup Start



Revision ID:

Item Name: Lug Plate, Fwd Crosstube

Stop



Start Date: 16/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

8 10/04/13

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

X12

150



Packaging

Packaging

Identify as per dwg & Stock Location: Q5

0.00

10-4-21

SP 12x

160



QC

Quality Control

Memo

0.00

0.00

10/04/22 HJ

ME 10-4-22



Lean is...

- Promote customer-orientation rather than resource-orientation (produce for sales not for stock).
- A highly evolved method of managing an organization to improve the productivity, efficiency and quality of its products or services.
- Transforms how the company operates and how employees think about their work. Don't work harder but smarter by transferring your energy from the NVA to the VA activities.
- Has no end (there is no "done").

Picklist Print

April 16, 2010 10:51:43 AM

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Work Order ID: 57824



Parent Item: D3909-1



Parent Item Name: Lug Plate, Fwd Crosstube

Start Date: 16/04/2010

Required Date: 29/04/2010

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC IPP RevB: as per revPA3
DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S11GA



304/316 0.125 Sheet

18 10-4-19

Warehouse	Loc Qty	Loc Code
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Location

Main Warehouse

MAT19	20.2
112663	20.2

112663

112663



Lean Is...

“LEAN IS... A mindset, or way of thinking

- A commitment to achieve a totally waste-free operation focused on the customer's success
- Achieved by simplifying and continuously improving all processes and relationships in an environment of trust, respect and full employee involvement
- It is about people, simplicity, flow, visibility, partnerships and true value as perceived by the customer.”

DART AEROSPACE LTD	Work Order: 57824
Description: <u>Lucy PLATE Fwd CROSS TUBE</u>	Part Number: D3909-1
Inspection Dwg: D3909-1, Rev: B	Page 1 of 1

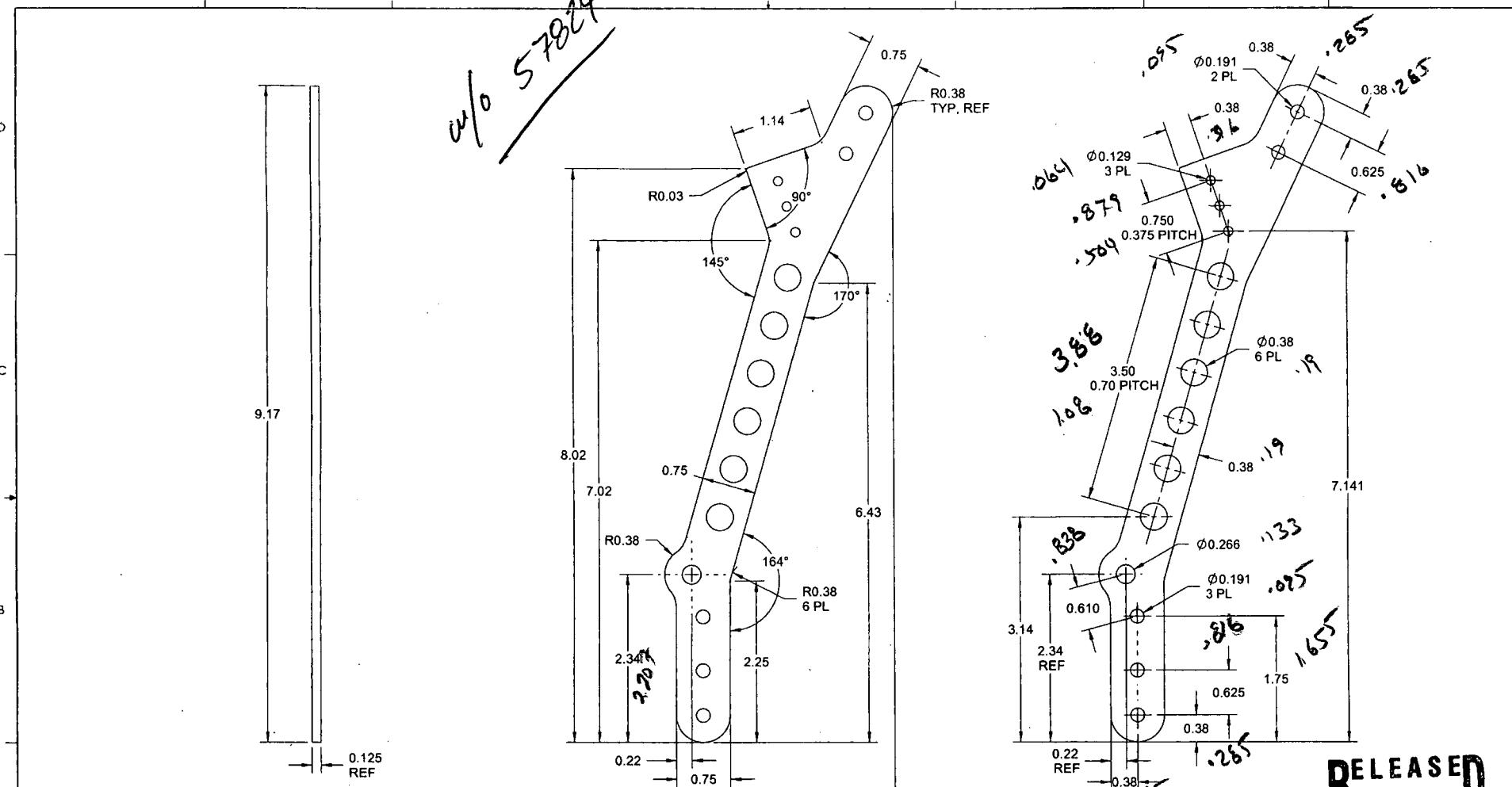
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi .174$	$+.005 -.001$.133	X			
$\phi .191$	$+.005 -.001$.194	X			
$\phi .366$	$+.006 -.001$.366	X			
$\phi .38$	$+.006 -.001$.380	X			
.75	$+.030$.757	X			
1.14	$+.030$	1.14	X			
.22	$+.030$.22	X			
2.34	$+.030$	2.344	X			
7.02	$+.030$	7.071	✓			
8.02	$+.030$	8.030	X			
.38	$+.030$.381	X			
.625	$+.010$.625	X			
.750	$+.010$.753	X			
.375	$+.010$.377	X			
3.50	$+.030$	3.508	X			
.70	$+.030$.704	X			
3.14	$+.030$	3.135	X			
.610 .224	$+.010$.608	X			
.625	$+.010$.624	X			
1.75	$+.030$	1.749	X			
7.141	$+.010$	7.142	✓			
.125	$+.010$.117	X			

Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval: <u>1</u>
Date: 10-4-19	Date: 10/04/19	Date: <u>10/04/19</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

D3909-1 FWD X-TUBE LUG PLATE

(SUPPLEMENTAL VIEW)

RELEASED
2010-04-07
W

DESIGN	JPH	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. B
MFG. APPR.		DRAWING NO.
APPROVED		D3909
DE APPR.		SHEET 3 OF 5
DATE	10.04.06	TITLE
		SCALE
		NTS

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Lean principle

To be able to produce exactly:

- **what is required**
- **when it is required**
- **the quantity required**

by the next step in the process.

Once a job started, it should ideally never stop